



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-122
Job Sheet 192043



Part No: D350-591-122

Job Qty: 3 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/14/19

Job Tracking No:

Due Date: 4/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 14381*

Note: DWG D2351-042 REV E, IIN-D350-591 REV H IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	3 pcs	4/2/19	4/2/19	0.00	2.40	Large Fab - 1		<i>ML</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
120	Skidtubes - Bend - 2 - B4B	3 pcs	4/2/19	4/2/19	0.00	0.00	Skidtubes - Bend - B4B		<i>DD</i>
122	QC 5	3 pcs	4/2/19	4/2/19	0.00	0.00	QC 5 - 10		<i>DAS</i> 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
126	Large Fab - Steps - 2 - B4B	3	4/2/19	4/2/19	0.00	3.37	Large Fab - 1 - B4B		

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				pcs	Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	DAS
					Large Fab - 6 - B4B	24
					Large Fab - 7 - B4B	9-89
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
130 QC 5	3 pcs	4/2/19	0.00 0.00	N/A	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
140 Large Fab - Welded Assy-2-B4B	3 pcs	4/2/19	0.00 2.50	N/A	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
150 QC 9	3 pcs	4/2/19	0.00 0.00		QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	DAS
					QC 9 - 50	43
					QC 9 - 9	9-89
160 QC 5	3 pcs	4/2/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	DAS
					QC 5 - 49	43
					QC 5 - 51	9-89
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	

170 Handfinish - 1-1 Chemical- B4B	3 pcs	4/2/19	0.00 0.00	QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	DR 19/03/27
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
180 QC 7	3 pcs	4/2/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	MAR 27 2019 68
				QC 7 - 50	9-89

190 Large Fab - Welded Assy-3-B4B	3 pcs	4/2/19	0.00 2.40	QC 7 - 67	
				QC 7 - 40	
				Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	DAS
				Large Fab - 4 - B4B	24
				Large Fab - 5 - B4B	9-89
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
220 QC 10	3 pcs	4/2/19	0.00 0.00	Large Fab - 9 - B4B	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	DAS
				QC 10 - 50	43
				QC 10 - 58	9-89
230 QC 5	3 pcs	4/2/19	0.00 0.00	QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	DAS
				QC 5 - 49	43
				QC 5 - 51	9-89
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
240 Handfinish - 1-2- Chemical-B4B	3 pcs	4/2/19	0.00 0.56	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/03/28
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	

				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
250	Powdercoat - 1 White Gl(A)- B4B	3 pcs	4/2/19	0.00 0.62	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
					Handfinish - 3 - 1 - B4B
					Handfinish - 3 - 2 - B4B
					Handfinish - 3 - 3 - B4B
					Handfinish - 3 - 4 - B4B
					Handfinish - 3 - 5 - B4B
260	Handfinish - 3-1- WingWalk- B4B	3 pcs	4/2/19	0.00 0.56	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
270	QC 3	3 pcs	4/2/19	0.00 0.00	Packaging 1 - 1 - B4B
					Packaging 1 - 2 - B4B
					Packaging 1 - 3 - B4B
					Packaging 1 - 4 - B4B
					Packaging 1 - 5 - B4B
					Packaging 1 - 6 - B4B
					Packaging 1 - 7 - B4B
					Packaging 1 - 8 - B4B
					Packaging 1 - 9 - B4B
					Packaging 1 - 10 - B4B
					Packaging 1 - 11 - B4B
					Packaging 1 - 12 - B4B
					Packaging 1 - 13 - B4B
					Packaging 1 - 14 - B4B
					Packaging 1 - 15 - B4B
					Packaging 1 - 16 - B4B
					Packaging 1 - 17 - B4B
					Packaging 1 - 18 - B4B
					Packaging 1 - 19 - B4B
					Packaging 1 - 20 - B4B
280	Packaging 1-1 - Pick Kit - B4B	3 pcs	4/2/19	0.00 0.00	

BR 19-03-28

AL 19-3-26

DAS
40
9-89
MAR 29 2019

					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	DAS
					Packaging 1 - 23 - B4B	46 MAR 29 2019
					Packaging 1 - 24 - B4B	9-89
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36	
					QC 4 - 28	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	DAS
					QC 4 - 46	46 MAR 29 2019
290 QC 4	3 pcs	4/2/19	0.00	0.00	Packaging 3 - 1 - B4B	9-89
					Packaging 3 - 2 - B4B	46 MAR 29 2019
					Packaging 3 - 3 - B4B	9-89
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
300 Packaging 3-1 - Stock - B4B	3 pcs	4/2/19	0.00	0.00	DC - 1 - B4B	DAS
						21 MAR 29 2019
305 DC - 1 - B4B	3	4/2/19	0.00	0.00		

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	pcs			DC - 2 - B4B	
310 QC 21 - FG	3	4/2/19	0.00 0.00	QC 21 - FG - 21	DAG
	pcs			QC 21 - FG - 70	21
				QC 21 - SA - 53	9-88

Part Op 110 - Fabricate per Drwg - 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup
 Descriptions: DT8185-G

- 120 - CNC Delta 100 Bender - Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041.
 122 - QC5- Inspect part completeness to step on W/O
 126 - Fabricate per Drwg) ***BUFF AND REMOVE BENDING MARKS WITHIN .005", if deeper see engineer***
 130 - QC5- Inspect part completeness to step on W/O
 140 - Weld per dwg A/R Aluminum rod Batch: 138872 Bevel Fwd and Aft end for welding
 150 - QC9- Inspect visual per QSI004- Fusion Welds
 160 - QC5- Inspect part completeness to step on W/O
 170 - Chemical Conversion Coat per QSI005 4.1
 180 - QC7-Inspect Chemical Conversion Coat
 190 - Weld per dwg A/R Aluminum rod Batch: _____ - 1-Rivet Leg Assembly as per Dwg D2351
 220 - QC10- Inspect visual per QSI004- ground welds
 230 - QC5- Inspect part completeness to step on W/O
 240 - Chemical Conversion Coat per QSI005 4.1
 250 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 260 - Wing Walk as per dwg QSI005 4.4 Batch _____
 270 - QC3- Inspect Part Finish
 280 - Pick Kit
 290 - QC4- 100% Inspect kits for completeness
 300 - Identify and pack for shipping as per PPP D350-591-121
 305 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-121 CHG005
 310 - QC21- Final Inspection - Work Order Release - 3-Do not Grind top edge Flush

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	1.5000 pcs (.5 ea)	110-Large Fab - Steps - 1	506509 F164533
D2850-2	End Cap	3 pcs (1 ea)	126-Large Fab - Steps - 2 - B4B	5153404
D2582	Hi-Skid Step Leg Assembly	3 pcs (1 ea)	190-Large Fab - Welded Assy-3- B4B	5161432
D2673-34	End Plate	3 pcs (1 ea)	190-Large Fab - Welded Assy-3- B4B	5157462
MS20600-AD4W3	Cherry Rivet	48 Ea (16 ea)	190-Large Fab - Welded Assy-3- B4B	5135486
AN3-37A	Bolt	8 6 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5158578
AN4-13A	Bolt	4 3 Ea (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5154301
AN4-16A	Bolt	8 6 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5154820
D2230-1	Mounting Lug	4 3 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5158039
D2230-3	Mounting Lug	4 3 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5148884
D2732-030	Rubber Cushion - 3"	8 6 pcs (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5157462
MS21042L3	Nut	8 6 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5161468
MS21042L4	Nut	12 9 Ea (3 ea)	280-Packaging 1-1 - Pick Kit - B4B	5152662
NAS1149D0363J	Washer	16 12 Ea (4 ea)	280-Packaging 1-1 - Pick Kit - B4B	5157445
NAS1149D0463J	Washer	24 18 Ea (6 ea)	280-Packaging 1-1 - Pick Kit - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2244-116	2	79	0
126-Large Fab - Steps - 2 - B4B	D2850-2	3	11	0
190-Large Fab - Welded Assy-3- B4B	D2582	3	10	0
	D2673-34	3	50	0
	MS20600-AD4W3	48	693	0
280-Packaging 1-1 - Pick Kit - B4B	AN3-37A	6	87	0
	AN4-13A	3	1,815	0
	AN4-16A	6	580	0
	D2230-1	3	311	0
	D2230-3	3	135	0
	D2732-030	6	426	0
	MS21042L3	6	3,616	0
	MS21042L4	9	4,463	0
	NAS1149D0363J	12	855	0
	NAS1149D0463J	18	6,901	0

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Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S165178



Part: D350-591-122

Job No: 192043

Serial No/Batch: S165178

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11, FAA STC SH967NE 04/12/21, BRAZIL 1

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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Part Number: D350-591-122

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, RH

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